

Date: Monday, 16/06/2008 10:25:27 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE		
Job Number	: 39888			Part Number	: D29331		
Estimate Number	: 10833			Drawing Number	: D2933 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 16/06/2008	S.O. No.	:	Drawing Revision	: C		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 04/07/2008	Qty:	6
Previous Run	: 37866			Um:	Each		
Written By	:			Comment	: Est: B00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		
Checked & Approved By	: <u>JUL 08/07/08</u>						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	<u>D6101001</u>	Saddle Billet
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 <u>Cut Size 2.0 x 6.25 X 6.00</u> <u>Grain Along Long 6.00 Length</u> <u>Batch No: B34872</u> <u>DISP 08/07/08</u>		
Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet		
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 16/06/2008 10:25:27 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 39888

Part Number: D29331

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 08/07/03

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

R.L 08/07/04 (6)

7.0 POWDER COATING POWDER COATING



m107925

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 7:40

OVEN TEMPERATURE: 320

FINISH TIME: 8:10

R.L 08/07/07 (6)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

R.L 08-07-07 (6)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 408A

8/7/1

(6) SB

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/07/08 (6)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11 08/07/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39888
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.123	.123	.122	.122	
B	0.100	0.140		.119	.119	.119	.119	
C	0.100	0.140		.134	.134	.120	.120	
D	0.210	0.230		.219	.219	.220	.221	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.500	.500	.510	.510	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.259	.259	.259	.259	
L	0.312	0.317		.313	.313	.313	.313	
M	0.235	0.240		.239	.238	.238	.238	
N	0.100	0.140		.121	.121	.121	.121	
O	0.540	0.560		.540	.540	.548	.550	
P	0.490	0.510		.500	.500	.510	.510	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.504	2.504	2.500	2.500	
S	0.240	0.270		.260	.250	.255	.255	
T	0.100	0.180		.135	.135	.135	.135	
U	1.625	1.635		1.627	1.627	1.627	1.627	
V	1.362	1.372		1.370	1.370	1.370	1.370	
W	0.316	0.321		.320	.320	.320	.320	
X	1.125	1.145		1.131	1.131	1.131	1.130	
Y	1.565	1.585		1.570	1.570	1.570	1.570	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by:	<i>SL</i>	Date:	<i>08/07/03</i>
Audited by:	<i>JL 08/07/03</i>	Date:	
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD <i>SL</i>	<i>SL</i>

DART AEROSPACE LTD	Work Order:	39808
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

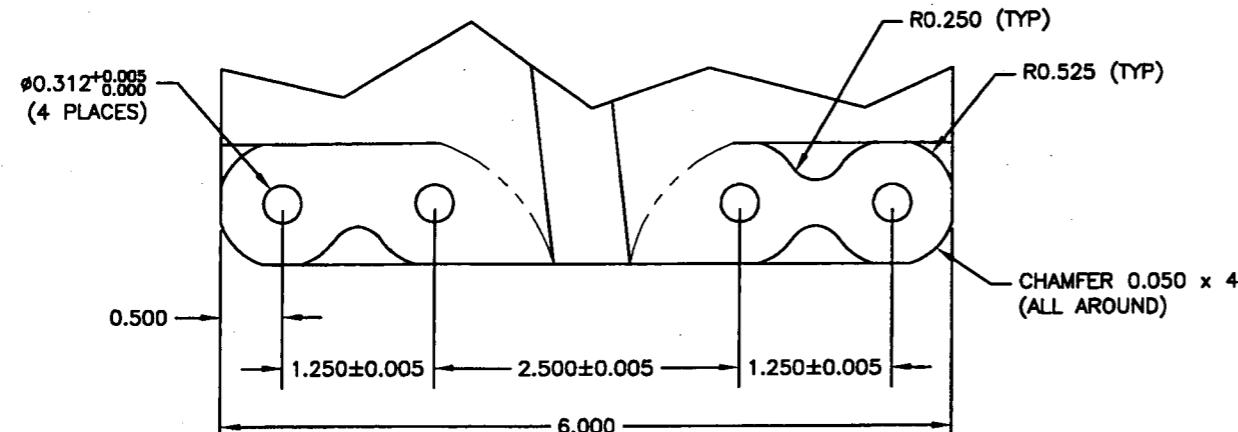
First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.120			
B	0.100	0.140		.117	.117			
C	0.100	0.140		.119	.119			
D	0.210	0.230		.221	.220			
E	1.245	1.255		1.250	1.250			
F	1.245	1.255		1.250	1.250			
G	2.495	2.505		2.500	2.500			
H	0.510	0.515		.510	.510			
I	1.572	1.582		1.577	1.577			
J	2.495	2.505		2.500	2.500			
K	0.257	0.262		.259	.259			
L	0.312	0.317		.313	.313			
M	0.235	0.240		.238	.238			
N	0.100	0.140		.121	.121			
O	0.540	0.560		.550	.550			
P	0.490	0.510		.510	.510			
Q	3.715	3.725		3.720	3.720			
R	2.470	2.510		2.500	2.500			
S	0.240	0.270		.250	.250			
T	0.100	0.180		.135	.135			
U	1.625	1.635		1.628	1.628			
V	1.362	1.372		1.370	1.370			
W	0.316	0.321		.320	.320			
X	1.125	1.145		1.130	1.131			
Y	1.565	1.585		1.572	1.575			
Z	0.178	0.198		.188	.188			
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by:	<u>SS</u>	Date:	08/07/03
Audited by:	<u>JL</u>	Date:	08/07/03
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	<u>JK</u> <u>DS</u>

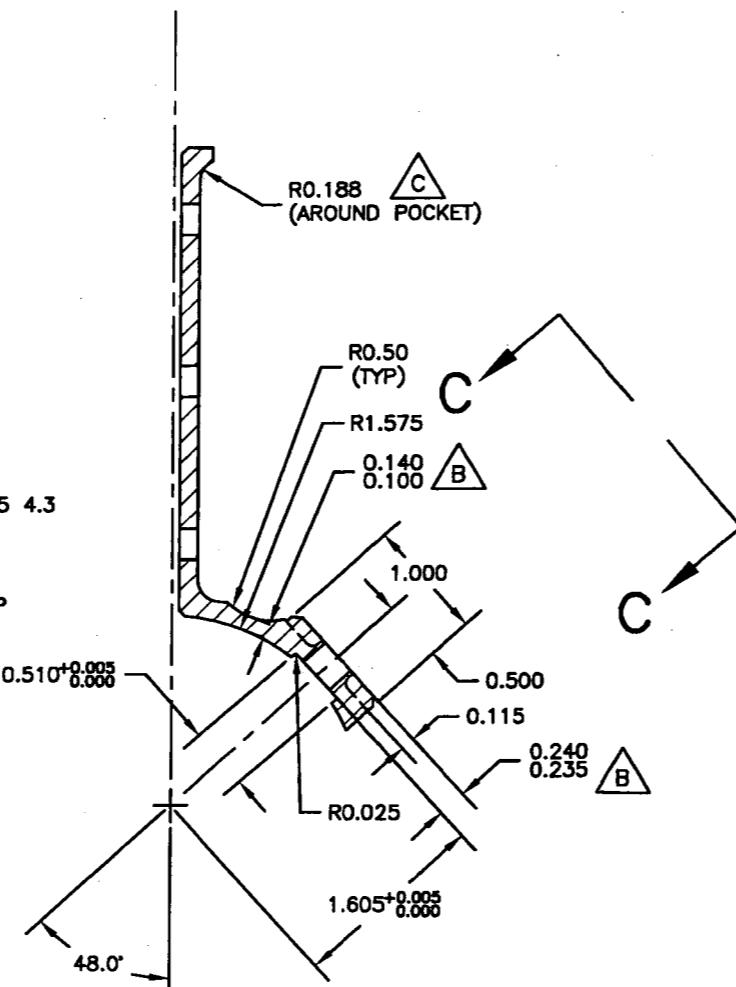


VIEW C-C

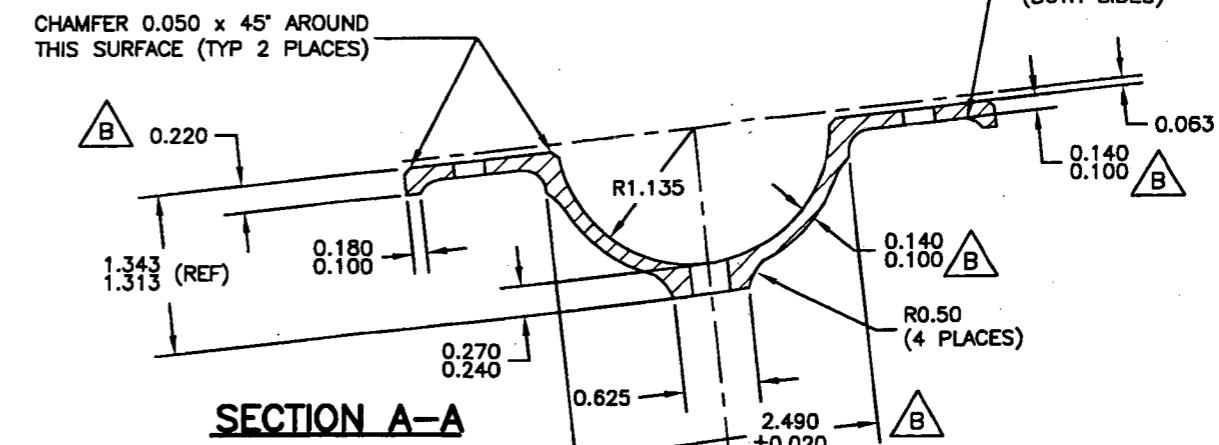
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

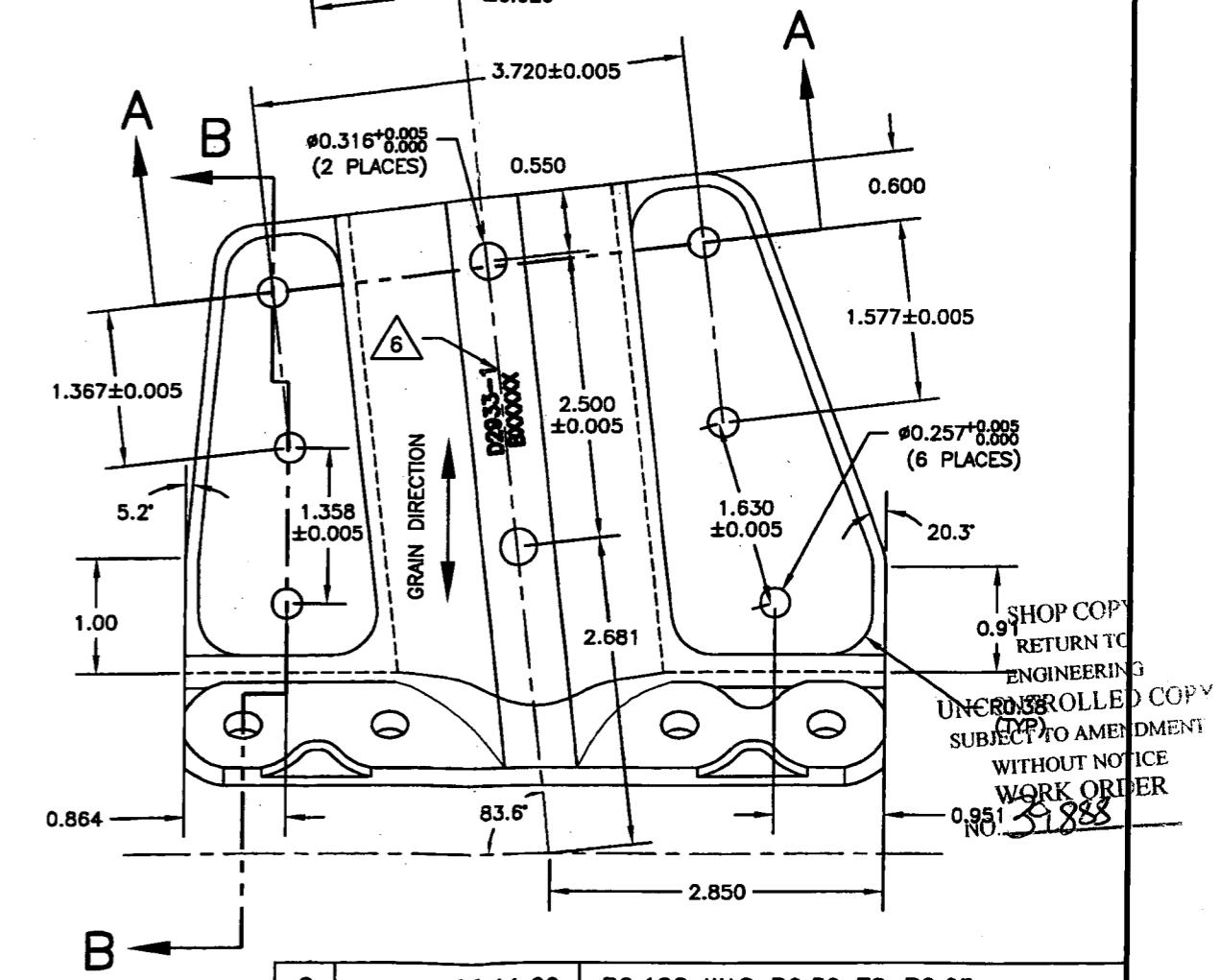
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

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DESIGN	4	DRAWN BY	CB	DART	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	APPROVED	#	DRAWING NO.	REV. C
DATE	06.11.09			TITLE	SCALE

D2933

SHEET 1 OF 1

2:3

RELEASED

07-02-12